

Date: Monday, 1/16/2006 4:19:33 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP WELDMENT
Job Number	: 25527		
Estimate Number	: 10777		
P.O. Number	: N/A	Part Number	: D3463042
This Issue	: 1/16/2006 S.O. No.: N/A	Drawing Number	: D3463 REV <i>AB</i>
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type: LARGE FAB ASSY	Drawing Revision	: <i>AB</i>
Previous Run	: 24918	Material	: N/A
Written By	: <i>SEE COMMENT BELOW</i>	Due Date	: 1/23/2006
Checked & Approved By	: <i>SEE COMMENT BELOW</i>	Qty:	1 Um: Each
Comment	: EST REV. A 05.11.18 new issue EC		

Additional Product:

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

238806

SS DOWEL PIN 1" LONG



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

* 2

238-806

SS DOWEL PIN 1" LONG

*M19080**06/01/31*

2.0

D34533

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

* 1

D3453-3

Clevis

*B25530**06/01/31*

3.0

D34637

Drag Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D3463-7

Drag Arm

*B25528**06/01/31*

4.0

D34631

Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

* 1


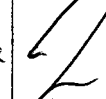

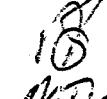

D3463-1

Arm

*B25531**B25742**06/01/31*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 06-02-14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-02-14	8	Step not flat and square after welding, due to holes to locate clevis, not being 90°. Step to far out at bottom and will not assemble.	 06-02-14	Scrap destroy and replace replace D3453-3 x1 } And re assemble 238-806 x2 } And weld as per Dwg. D3463-1 x1 } D3463-3 x1	 06-02-14	 06-02-15	 06-02-14	 06-02-14

NOTE: Date & initial all entries

Date: Monday, 1/16/2006 4:19:33 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 25527

Part Number: D3463042^s

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34633

Step



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
* 1	D3463-3	Step	B25718 D25532

06/01/31

6.0

D34635F

End Cap



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3463-5F	Step Flat Pattern	25529

06/01/31

7.0

D34535

Plug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3453-5	Plug	B25533

06/01/31

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3463

06/02/14

9.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

06-02-15
PD 06-02-15

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- Mask areas indicated on dwg D3463 (holes, threads)

2-Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

06-02-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/16/2006 4:19:33 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 25527

Part Number: D3463042

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3463 and QSI 005 4.4

a.m. 06-02-15

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 060215

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 06/02/16

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Sys 06/02/17

(1)

06/02/17 (1)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

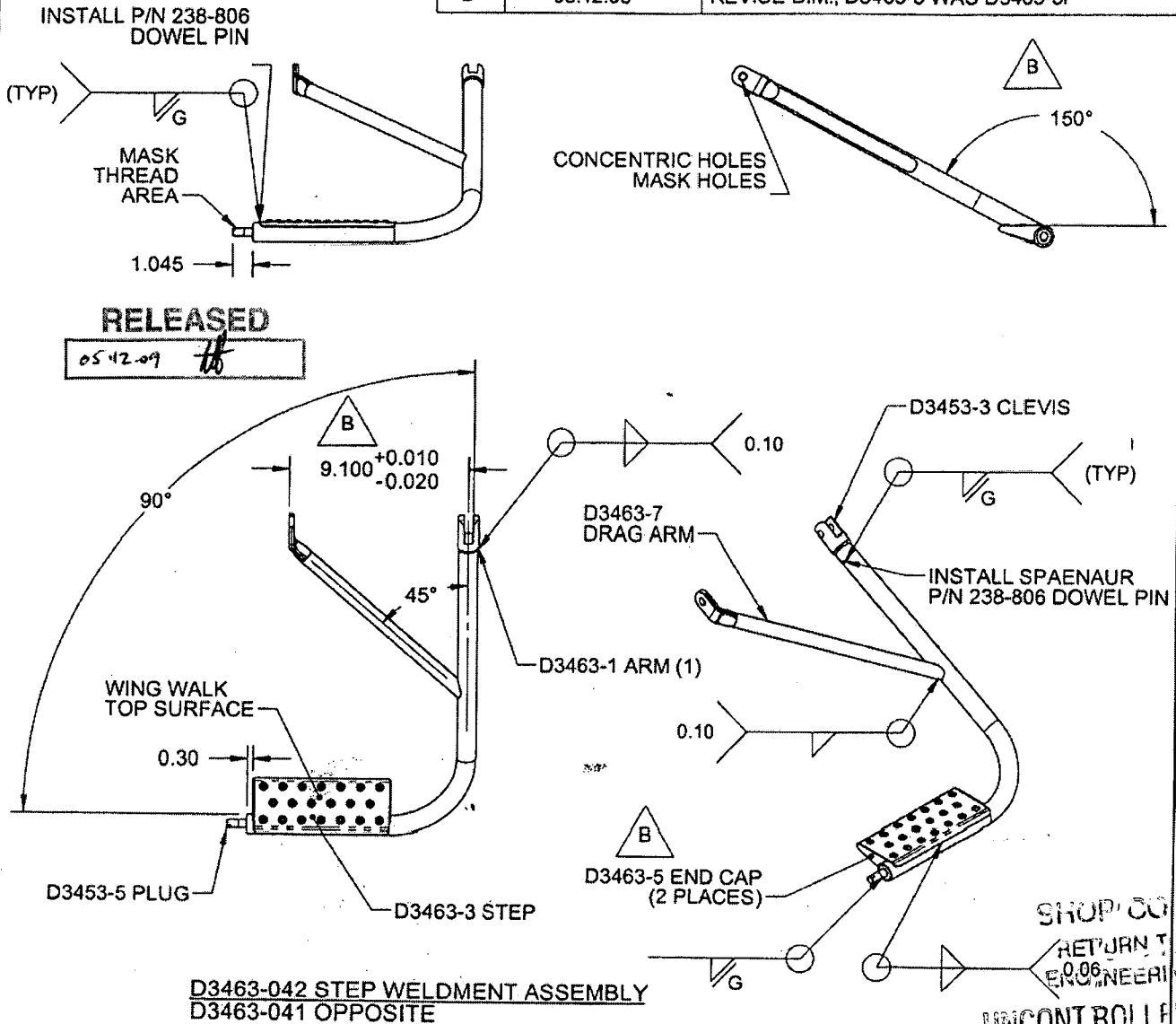
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 1 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

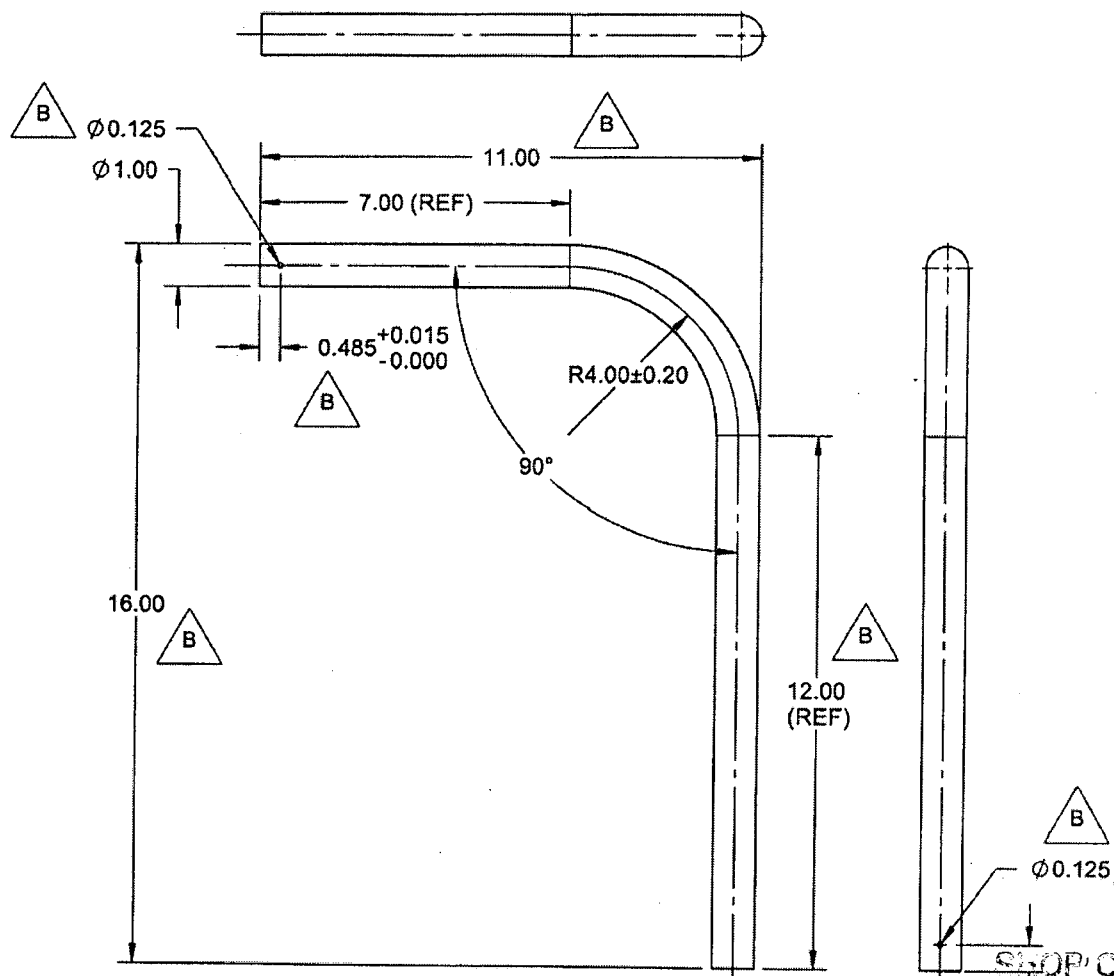
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WORK ORDER
NO 25527

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3463	REV. B SHEET 2 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:4

RELEASED05.12.09 *[Signature]***D3463-1 ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

0.610^{+0.015}_{-0.000}
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25527

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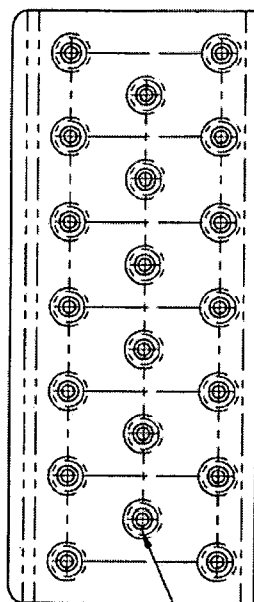
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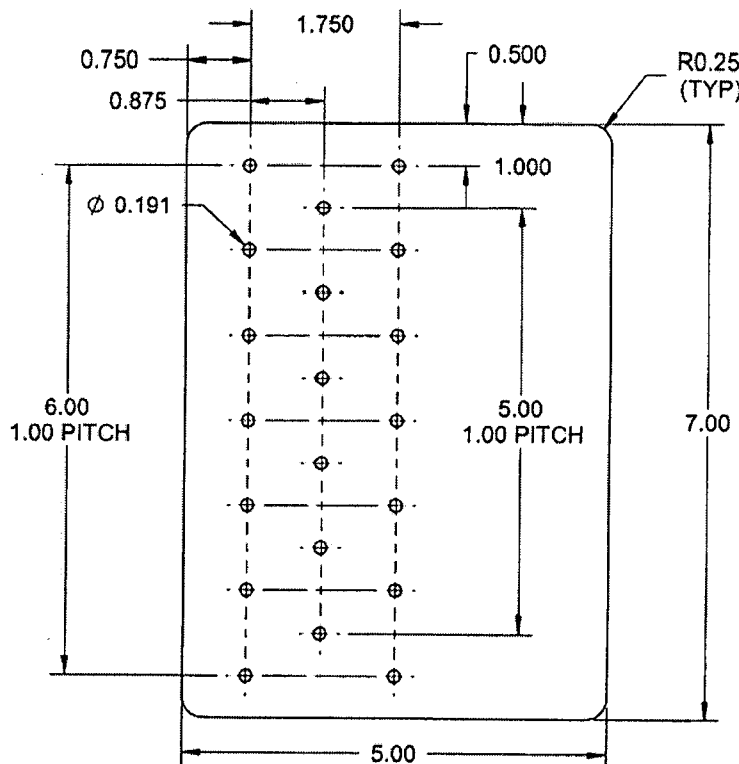
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 4 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:2

RELEASED

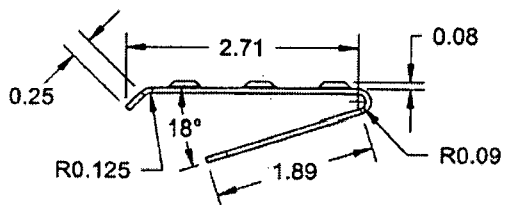
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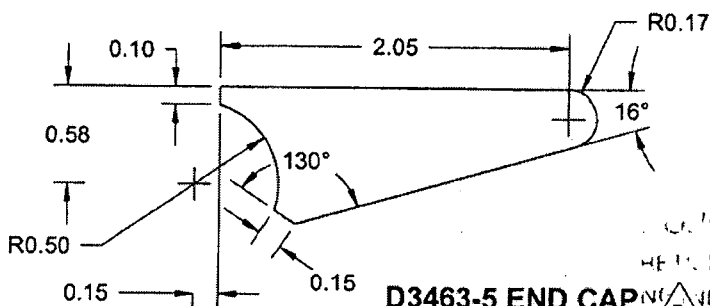
FORM USING
D3463-3T1



D3463-3F FLAT PATTERN



D3463-3 STEP



D3463-5 END CAP
SCALE 1:1

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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WORK ORDER

NO. 25527

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